

Date: Tuesday, 14/04/2009 8:48:18 AM  
User: Linda Lacelle

Ship 15/04 if possible

Dart Aerospace Ltd.

Process Sheet

for Eagle

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 47129  
**Estimate Number** : 12969  
**P.O. Number** :  
**This Issue** : 14/04/2009 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : / / **Type** : SMALL /MED FAB  
**Previous Run** : 45190  
**Written By** :  
**Checked & Approved By** :  
**Comment** : Est Rev :A New Issue 07.07.23 EC verified by:JLM

**Drawing Name** : CABIN FLOOR PROTECTOR  
**Part Number** : D35745  
**Drawing Number** : D3574 UNDER REVIEW  
**Project Number** : N/A  
**Drawing Revision** : \* B E 09.04.15  
**Material** :  
**Due Date** : 16/04/2009 **Qty:** 4 **Um:** Each

Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 MLEXS125F6002904 GE PLASTICS LEXAN SHEET



**Comment:** Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)  
lexan sheet  
Batch: 109455 B 9-4-15

2.0 WATER JET FLOW WATER JET



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3574  
Dwg Rev: B  
Prog Rev: B

B 9-4-15

(4)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-15

4.0 QC8 SECOND CHECK



**Comment:** SECOND CHECK

S 09/04/15

(4)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD

09-04-16

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47129
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> <del>A</del> B	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.002	x			
7.37	+/-0.030	7.37	x			
11.00	+/-0.030	11.00	x			
15.25	+/-0.030	15.25	x			
25.87	+/-0.030	25.87	x			
39.75	+/-0.030	39.75	x			
44.75	+/-0.030	44.75	x			
58.38	+/-0.030	58.38	x			
63.50	+/-0.030	63.50	x			
65.25	+/-0.030	65.25	x			
11.87	+/-0.030	11.87	x			
14.75	+/-0.030	14.75	x			
26.00	+/-0.030	26.00	x			
40.87	+/-0.030	40.87	x			
45.00	+/-0.030	45.00	x			
48.00	+/-0.030	48.00	x			
55.13	+/-0.030	55.13	x			
61.25	+/-0.030	61.25	x			
61.88	+/-0.030	61.88	x			
64.63	+/-0.030	64.63	x			
7.63	+/-0.030	7.63	x			
11.00	+/-0.030	11.00	x			
22.50	+/-0.030	22.50	x			
35.13	+/-0.030	35.13	x			
36.50	+/-0.030	36.50	x			
40.00	+/-0.030	40.00	x			
41.88	+/-0.030	41.88	x			
43.63	+/-0.030	43.63	x			

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47/29
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 2 of 2</b>	

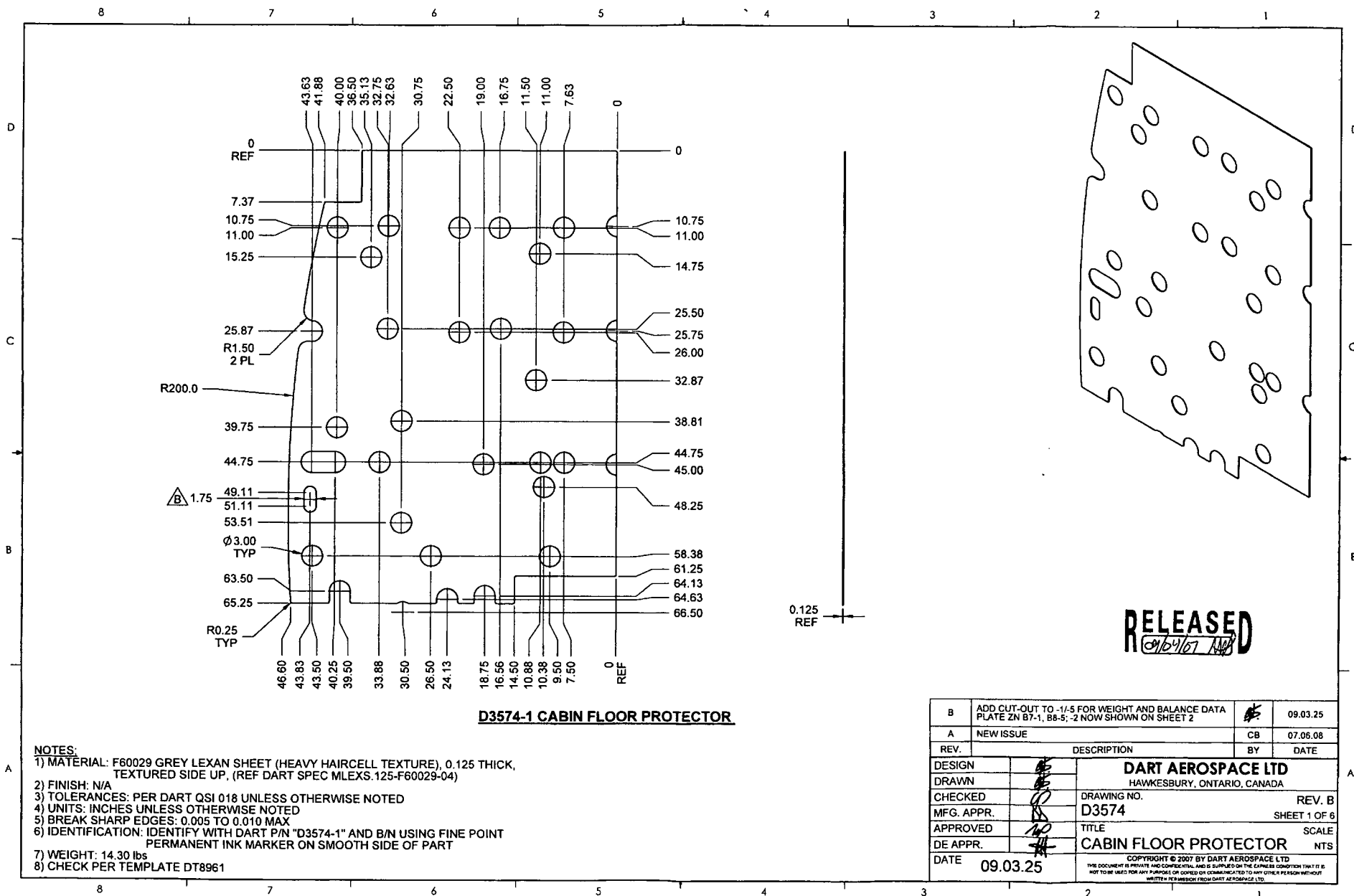
### FIRST ARTICLE INSPECTION CHECKLIST

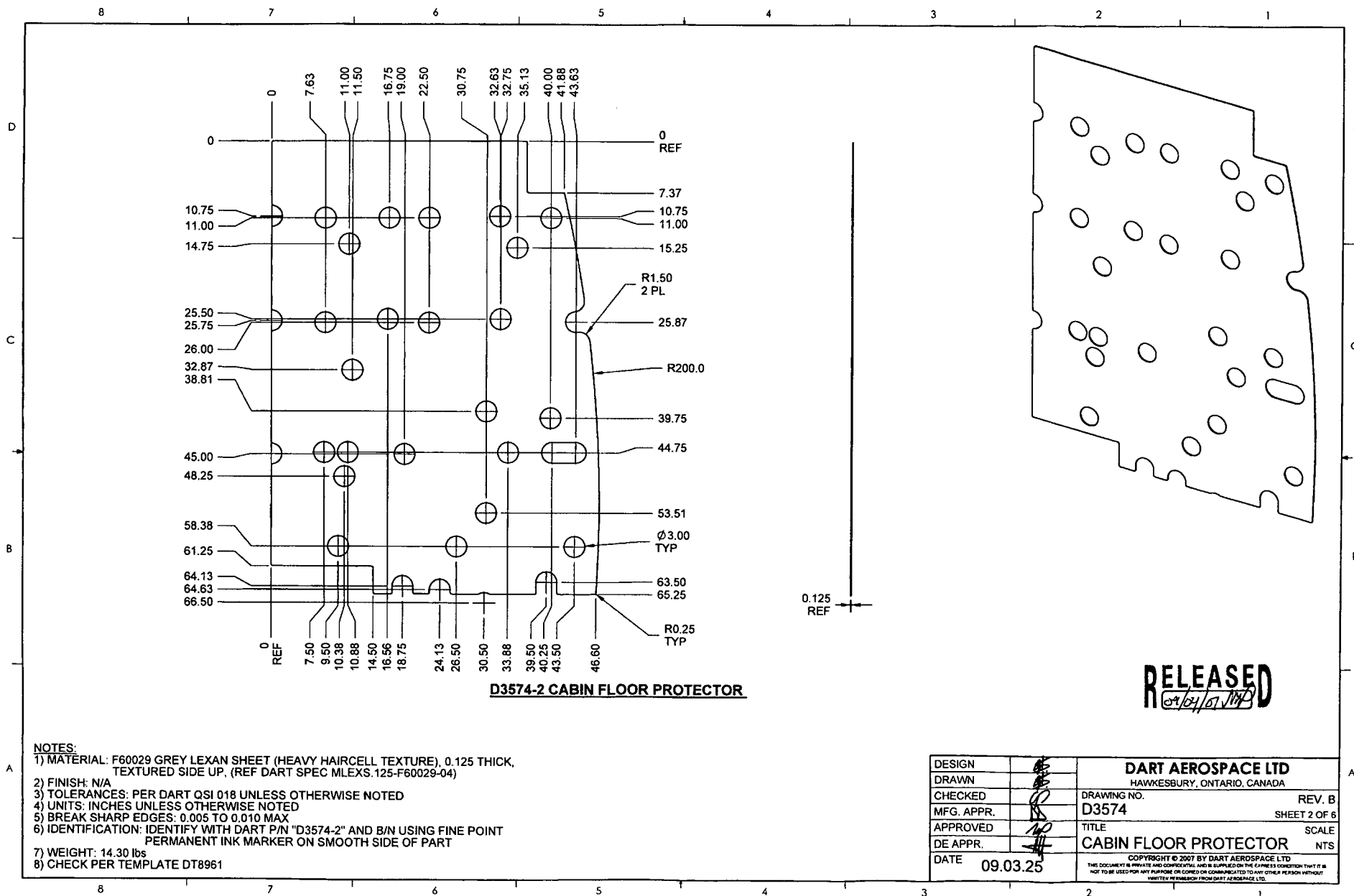
☒ First Article      ☐ Prototype

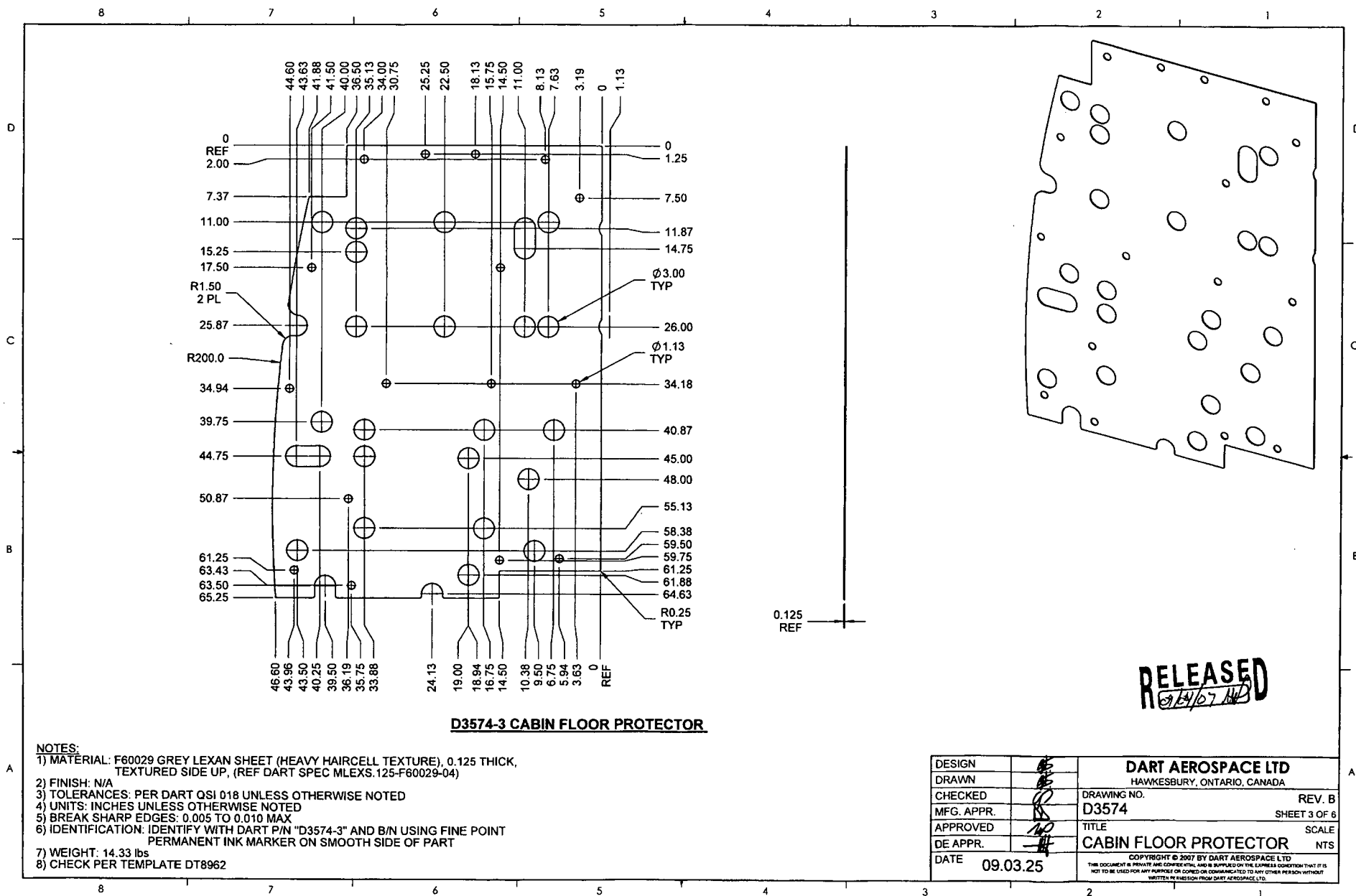
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	+/-0.030	6.75	x			
9.50	+/-0.030	9.50	x			
10.38	+/-0.030	10.38	1			
14.50	+/-0.030	14.50	x			
16.75	+/-0.030	16.75	x			
18.94	+/-0.030	18.94	x			
19.00	+/-0.030	19.00	x			
24.13	+/-0.030	24.13	x			
33.88	+/-0.030	33.88	x			
39.50	+/-0.030	39.50	x			
40.25	+/-0.030	40.25	x			
43.50	+/-0.030	43.50	x			
46.60	+/-0.030	46.60	x			
43.83	+/- .030	43.83	x			
49.11	+/- .030	49.11	x			
51.11	+/- .030	51.11	x			
1.75	+/- .030	1.746	x			
.125	+/- .010	.126	x			

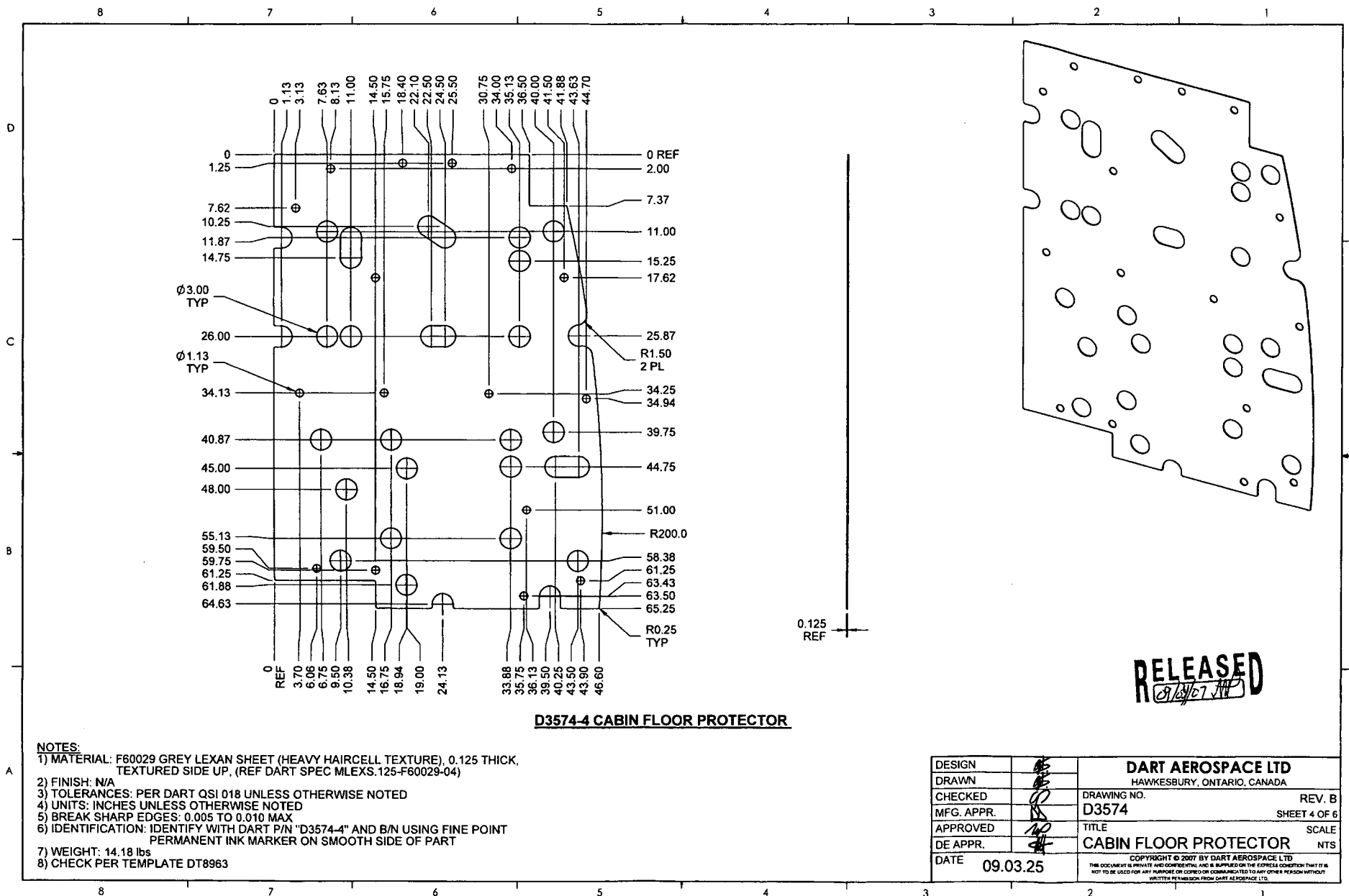
<b>Measured by:</b>	RB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	9-4-15	<b>Date:</b>	09/04/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	

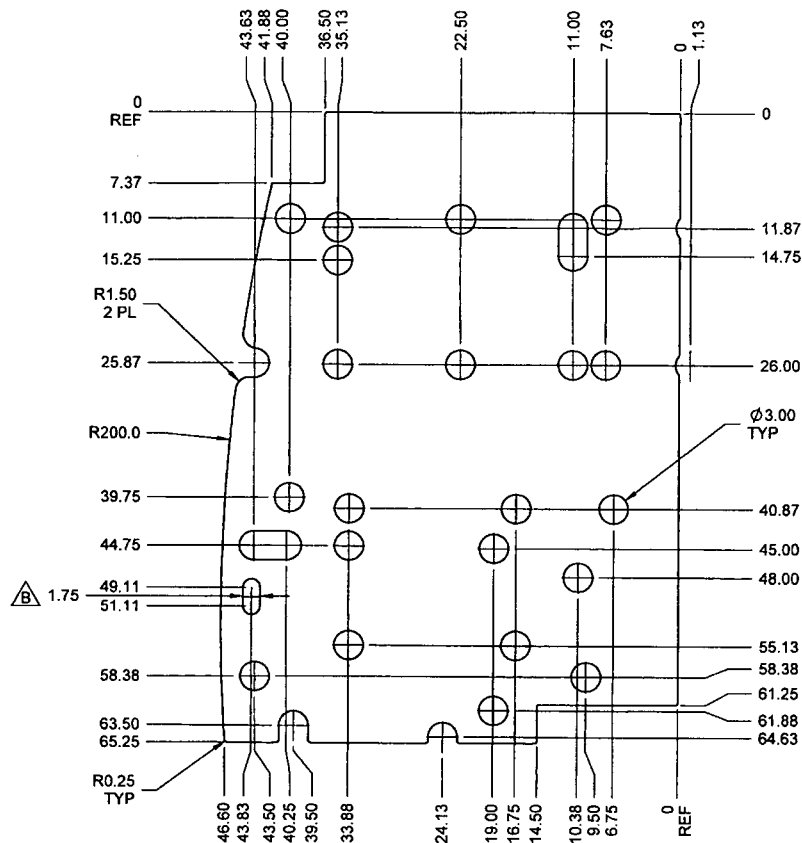












**D3574-5 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

**RELEASED**  
09/04/07 JWP

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3574</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>CABIN FLOOR PROTECTOR</b>	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

